

Work Order ID 81850-1

March-19-12 4:25:16 PM

81850

Page 1

Item ID: D4406-043

Revision ID:

Item Name: Aft Wearplate Assembly

Start Date: 19/03/2012 Start Qty: 8.00

Required Date: 02/04/2012 Req'd Qty: 8.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: MLJ

QC:

Date: 12/03/20

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4406

B

100

100

Waterjet

FLOW CNC Waterjet

304 .050

Memo

1-Cut as per dwg D4406-3

prog rev:

dwg rev:

2-Deburr if required

0.00

0.00

B 12-4-7

8

1

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

B 12-4-7

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Page 2

Item ID: D4406-043

Accept

N900040100

Revision ID:

Setup Start ***NS1***

Item Name: Aft Wearplate Assembly

Stop ***NS2***

Start Date: 19/03/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 02/04/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Quality Control

Memo

0.00

S. 12/10/12

(X)

130

0.00

130

Small Fab

Memo

0.00

Small Fab

Form as per dwg D4406

(S)

(S)

S. 12/10/12

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Quality Control

Memo

0.00

S. 12/10/12

(X)

Work Order ID 81850

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Page 3

Item ID: D4406-043

Revision ID:

Item Name: Aft Wearplate Assembly

Start Date: 19/03/2012 Start Qty: 8.00

Required Date: 02/04/2012 Req'd Qty: 8.00

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
150									
Large Fab									
Large Fab	Memo	0.00							
	Weld bar as per dwg								
	A/R 2059b hardcoat Batch#: <u>M121175</u>								
	Weld bar to wearplate as per dwg								
	A/R s.s. rod Batch #: <u>M120013</u>								
160									
160									
QC									
Quality Control									
165									
QC									
170									
170									
Small Fab									
Small Fab	Memo	0.00							
	Apply coating as per dwg D4406								
	<u>B120858</u>								

(x4)

MAL

12/04/26

4x

Ø

12/04/26

0.00

Enkita

0.00

(ell)

AS

12-4-26 (4)

Work Order ID 81850

March-19-12 4:25:16 PM

81850

Page 4

Item ID: D4406-043

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Alt Wearplate Assembly

Stop ***NS2***

Start Date: 19/03/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 02/04/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				4	0	BR	12-4-27
190 *190* Packaging Packaging	Identify as per dwg & Stock Location: <u>FP-1</u> Memo	0.00 0.00				4x	0		12/4/30 48
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							12/4/30 48

12/4/30 48

Picklist Print

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Page 1

Work Order ID: 81850

Parent Item: D4406-043

Parent Item Name: Aft Wearplate Assembly

81850

D4406-043

Start Date: 19/03/2012

Required Date: 02/04/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev A 11.06.06new issue EC verified by:DD
12.02.06 as per dwg revPB1 DD verf:EC

IPP rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			100	sf	191.1180	2.92	24.58947			

M304S18GA

304/316 .050 Sheet

**

B12-4-7

8

Location

Loc Qty

Loc Code

MAT020

191.118

119032

10.3

119383

60.818

120604

120

150

Each

4.0000

2

**

16
(x8)

MAL

12/04/26

D4407-3

D4407-3

Bar

B80759 x6

B81851 x2

Location

Loc Qty

Loc Code

ENG

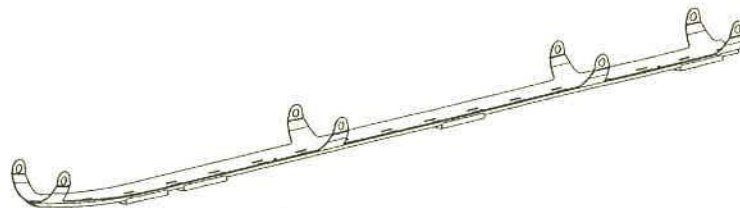
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WA

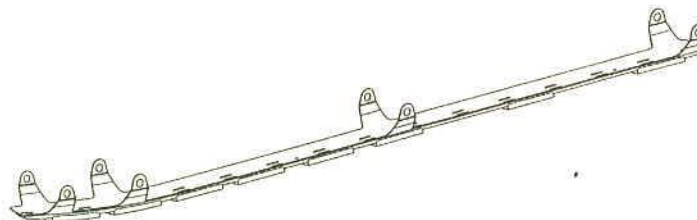
14

80796

4



D4406-041 FWD WEARPLATE ASSY



D4406-043 AFT WEARPLATE ASSY

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D4406-041	FWD WEARPLATE ASSY
2		X	D4406-043	AFT WEARPLATE ASSY
3	1		D4406-1	PLATE
4		1	D4406-3	PLATE
5	2		D4407-1	BAR
6		2	D4407-3	BAR
7	A/R	A/R	2059B	HARDCOAT
8	A/R	A/R	4714	PLUS ONE ROCKGUARD (SEE NOTE 10, SHT 2 & 3)

SHOP COPY
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SUBJECT TO AMENDMENT

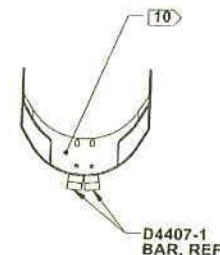
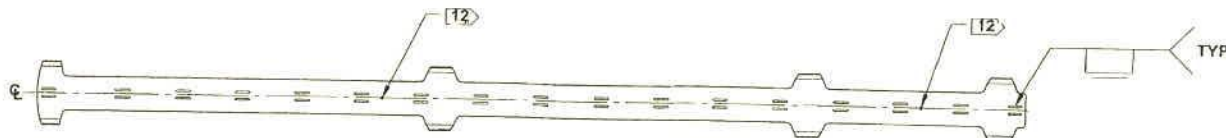
WITHOUT NOTICE
WORK ORDER

NO. 81850 MJS

12/03/20

RELEASE
R 2012-02-23
MO

B	REVISE BILL OF MATERIAL. ADD NOTE 13/14 & REVISE NOTE 9 SHT 2 & 3, MODIFY DETAIL E & F (ZN B3-6, C2-6), ADD DETAIL G (ZN C7-6). REVISE D4406-3F TAB LOCATIONS (ZN B5-5)	RF	12.02.16
A	NEW ISSUE	RF	11.08.15
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4406	SHEET 1 OF 6
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	WEARPLATE ASSY	NTS
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D4406-041 FWD WEARPLATE ASSY

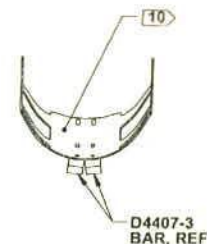
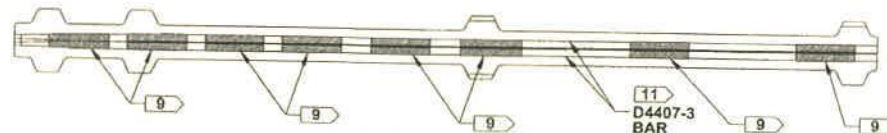
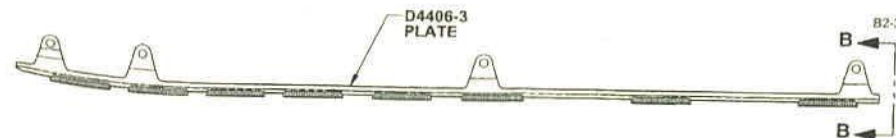
SECTION A-A C3-2
SCALE 2X

RELEASED
2012-02-23

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 8.40 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.37 THICK x 0.50 WIDE, FLUSH WITH D4407-1 BAR ON LATERAL SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) FORM TO MATCH PROFILE OF D4406-1 AT TIME OF WELDING
- 12) TRANSFER $\varnothing 0.188$ HOLES FROM D4406-1 TO D4407-1
- 13) NOTCH D4407-1 BARS AS REQUIRED TO FORM TO D4406-1 PLATE

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D4406-043 AFT WEARPLATE ASSY

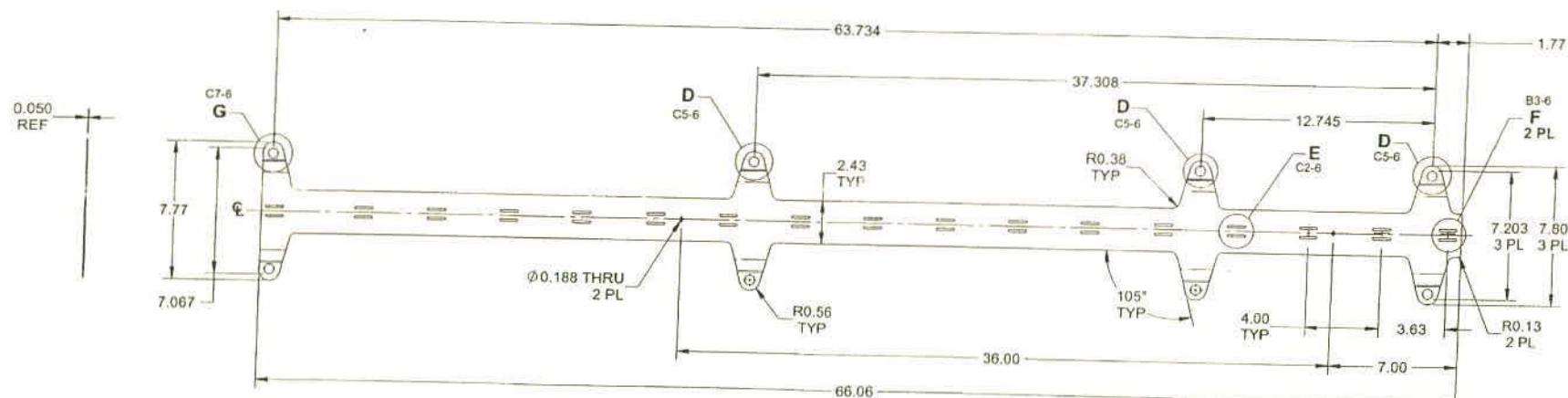
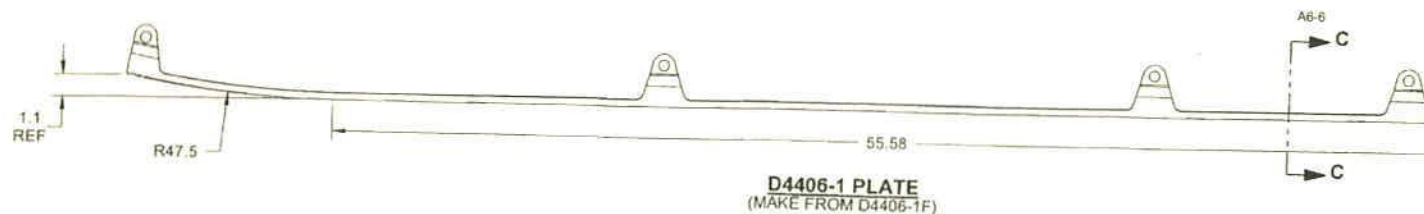
SECTION B-B C3-3
SCALE 2X

RELEASE
2012-02-23

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 8.73 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.37 THICK x 0.50 WIDE, FLUSH WITH D4407-3 BAR ON LATERAL SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) FORM TO MATCH PROFILE OF D4406-3 AT TIME OF WELDING
- 12) FILL TOOLING HOLE WITH WELD ONE PLACE ONLY
- 13) TRANSFER $\varnothing 0.188$ HOLES FROM D4406-3 TO D4407-3
- 14) NOTCH D4407-3 BARS AS REQUIRED TO FORM TO D4406-3 PLATE

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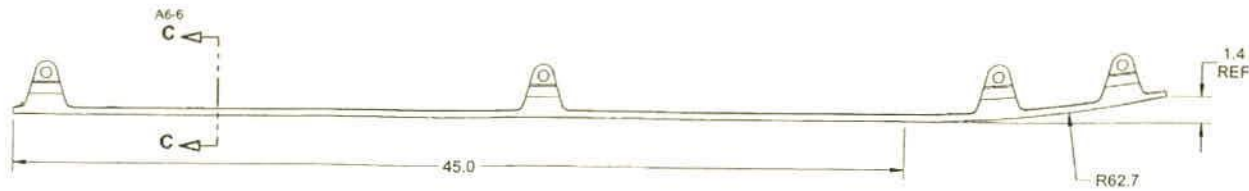
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.050 THICK (18 GAUGE)
PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.7 lbs

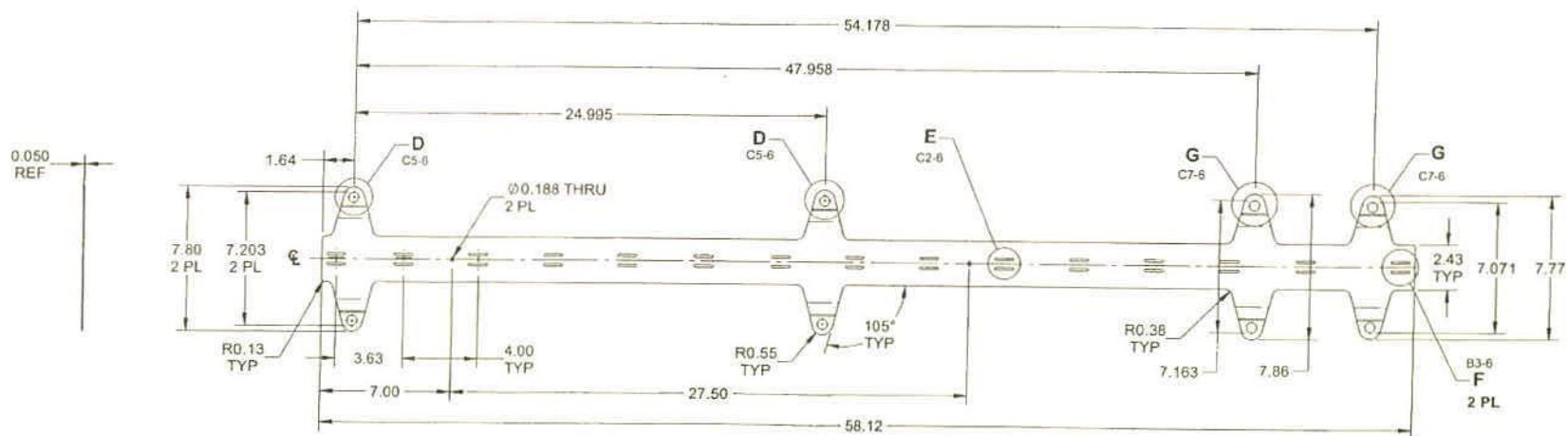
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D4406-3 PLATE
(MAKE FROM D4406-3F)



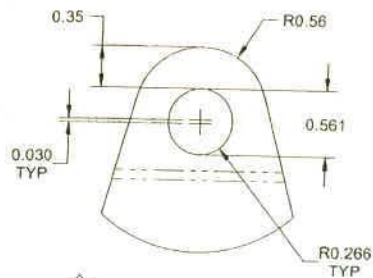
B D4406-3F FLAT PATTERN

NOTES:

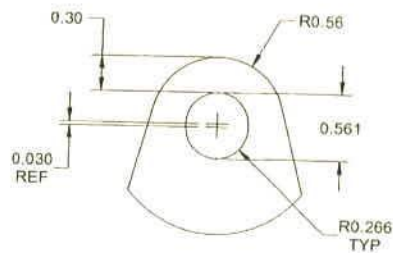
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.050 THICK (18 GAUGE)
PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.4 lbs

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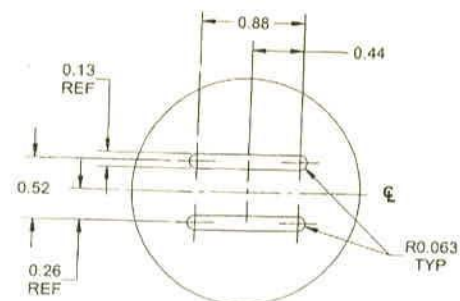
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DATE	12.02.16		



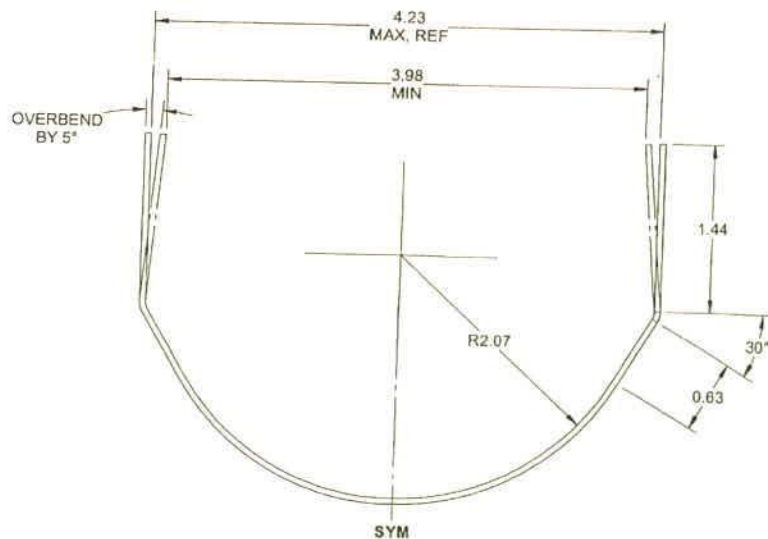
DETAIL G
SLOT DETAIL TYP
SCALE 6X
C7-4
C2-5
C3-5



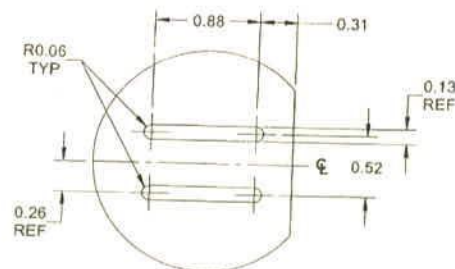
DETAIL D
SLOT DETAIL TYP
SCALE 6X
C2-4
C3-4
C5-4
C5-5
C6-5



DETAIL E
SLOT DETAIL TYP
SCALE 6X
C2-4
C3-5



DETAIL C
DETAIL TYP
SCALE 6X
D2-4
D6-5



DETAIL F
SLOT DETAIL TYP
SCALE 6X
C1-4
B1-5

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